Monday, 2/5/2007 10:55:37 AM Dåte: Kim Johnston User: **Process Sheet** : BRACKET **Drawing Name** : CU-DAR001 Dart Helicopters Services Customer Job Number : 30636 : 12530 **Estimate Number** : D35471 Part Number AIG: P.O. Number S.O. No. : 4/A D3547 **Drawing Number** : 2/5/2007 This Issue : N/A : NC Project Number Prsht Rev. : A 🎋 : SMALL /MED FAB **Drawing Revision** : 2/5/2007 First Issue Type :NIA : 28631 Material Previous Run Each : 2/12/2007 **Due Date** Written By Checked & Approved By New Issue 06-09-18 : Est Rev: Comment **Additional Product** Job Number: Description: Machine Or Operation: Seq. #: 2024-T3 .125 sheet M2024T3S125 1.0 Comment: Qty.: •0<del>.5</del>565 sf(s) 0.0557 sf(s)/Unit Total: 2024-T3 .125 Sheet (M2024T3S0125) Batch: MIDL 0102 12 Comment: FLOW WATER JET 1-Cut as per Dwg D3547 070212 Dwg Rev: A Prog Rev: A \*\*\*\*Ensure Grain Direction is Correct\*\*\*\*\* 2-Deburr if necessary 3.0 QC2 0702 12 PARTS AS THEY COME OFF MACHINE SECOND CHECK 4.0 QC8 Comment: SECOND CHECK NC BRAKE BRAKE NC 5.0 Comment: NC BRAKE Bend as per Dwg D3547

Page 1

### **Dart Aerospace Ltd**

W/O:		WORK ORDER CHANGES																					
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Part No:	PAR #:	Fault Category:	NCR: Yes No DQA:	Date: 1/12/2
			QA: N/C Closed:	Date:

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
		Description of NC	Description of NC Corrective Action Section B			Verification	Approval	Approval
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Section C	Approval Chief Eng	Approval QC Inspector
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NOTE: Date & initial all entries

Monday, 2/5/2007 10:55:37 AM Qate: Kim Johnston User: **Process Sheet** Drawing Name: BRACKET Customer: CU-DAR001 Dart Helicopters Services Job Number: 30636 Part Number: D35471 Job Number: Description: Seq. #: Machine Or Operation: INSPECT WORK TO CURRENT STEP 6.0 QC5 Comment: INSPECT WORK TO CURRENT STEP HAND FINISHING1 HAND FINISHING RESOURCE #1 Comment: HAND FINISHING RESOURCE #1 Chemical Conversion Coat as per QSI 005 4.1 8.0 POWDER COATING M1102141 Comment: POWDER COATING Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3 9.0 POWDER COAT/CHEMICAL CONVERSION PACKAGING RESOURCE #1 PACKAGING 1 10.0 Comment: PACKAGING RESOURCE #1 Identify and Stock Location: QC21 11.0 Comment: FINAL INSPECTION/W/O RELEASE u A.D. 22 Job Completion

# Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	
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Part No	:	PAR #: Fault Category:	NCR: Yes	No DQ	<b>A</b> :	Date:		

QA: N/C Closed: \_\_\_\_ Date: \_\_\_\_

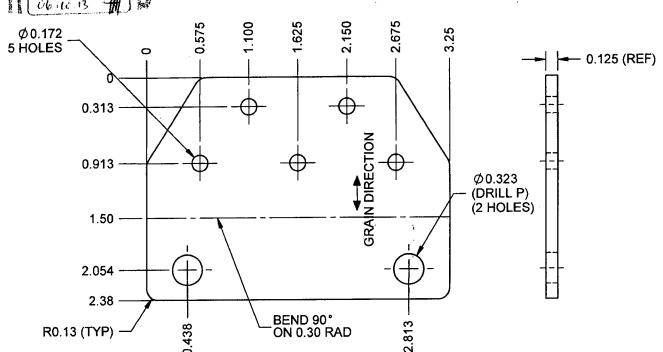
NCR:		WORK ORDER NON-CONFORMANCE (NCR)							
	T	Description of NC		Corrective Action Section I	3	Verification	A	A	
DATE	STEP	Section A	Initial   Action Description   Sign & Chief Eng   Date		Sign & Date	Section C	Approval Chief Eng	Approva QC Inspecto	
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NOTE: Date & initial all entries

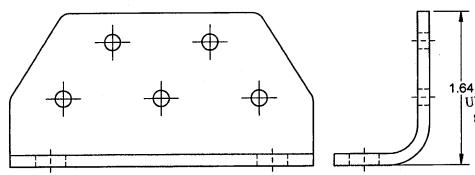


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DESIG	Ņ Ņ	DRAWN BY		AEROSPACE LTD BURY, ONTARIO, CANADA
CHECK	CED PH	APPROVED	DRAWING NO. D3547	REV. A SHEET 1 OF 1
DATE 06.10.06		BRACKET	SCALE 1:1	
REV		DATE		DESCRIPTION
Α		06.10.06	NEW ISSUE	



#### **D3547-1F FLAT PATTERN**



SHOP COPY RETURN TO ENGINEERING UNCONTROLLED COPY SUBJECT TO AMENDMENT WITHOUT NOTICE WORK ORDER

#### **D3547-1 BRACKET**

NOTES:

1) MATERIAL: 6061-T6 ALUMINUM 0.125 THICK PER QQ-A-250/11 (REF DART SPEC M6061T6S.125)

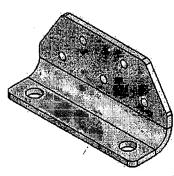
2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

- 4) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED 5) BREAK ALL SHARP CORNERS TO 0.010 MAX

6) IDENTIFY WITH P/N D3547-1 USING FINE POINT PERMANENT INK MARKER



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TARE APPOCRACE LTD	Work Order:	30636
DART AEROSPACE LTD		
	Part Number:	25117-1
Description: Bracket	Part Number.	0.534 1 1
Description. Dracket		
		Page 1 of 1
Inspection Dwg: 1)2547 Rev: A		

## FIRST ARTICLE INSPECTION CHECKLIST

X	First Article	XF	Prototype
	First Aiticle	السلسا	

Drawing Dimension	Tolerance	Actual Dimension	Accept	leject	Method of Inspection	Comments
Ø0.172	100.005-0.001	0.173	1		Vern	
00.323	100.00-200.04	0.323	✓		vern	
3.25	+1-0-030	3.255	1		Norn	
2.38	+1-0.030	2.38	1		VerN	
0,313	+1-0.010	0.316	1		VerN	
0.913	+1-0.010	0.916	1		YLVN	
0.438	41-0.010	0.440	V		vern	
2.813	+1-0.010	2.815	<b>√</b>		Vern	
0.125	+1-0.010	0.123	<b>√</b>	-	VerN	
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Measured by:	and mil	Audited by:	Prototype Approval:	
	07 07 17	Date: 17-07-12	Date:	
	010212		Revised b	Approved

Rev	Date	Change	KJ/JLM
Α		New issue	KJ/JEW